

CLAIMS

What is claimed is:

1. A method of producing a printed packaging material comprising:
 - 5 applying an actinic radiation activatable liquid ink to a packaging material;
 - exposing the ink to first actinic radiation;
 - 10 applying an energy-curable coating over the ink; and
 - curing the coating with second actinic radiation.
2. The method of claim 1, wherein the packaging material is a thermoplastic flexible film, and wherein a to-be-packaged substance is enclosed within the plastic film subsequent to the actinic radiation curing thereof.
3. The method of claim 1, wherein the packaging material is a foil laminate paper or paper plastic laminate, and wherein a to-be-packaged substance is enclosed within the plastic film subsequent to the actinic radiation curing thereof.
4. The method of claim 1, wherein the first actinic radiation is UV light.
- 15 5. The method of claim 1, wherein the second actinic radiation is an electron beam.
6. The method of claim 1, wherein the second actinic radiation is UV light.
7. The method of claim 1, wherein the energy-curable coating is free of pigment.
8. The method of claim 1, wherein the liquid ink is applied more than once.
9. The method of claim 1, wherein the liquid ink is solvent-based.
- 20 10. The method of claim 1, wherein the liquid ink is water-based.
11. A packaging material produced according to the method of claim 1.
12. The packaging material of claim 11, wherein the packaging material contains less than 700 ppm total of residual solvent or water.

13. The packaging material of claim 12, wherein the packaging material contains less than 600 ppm total of residual solvent or water.

14. The packaging material of claim 13, wherein the packaging material contains less than 500 ppm total of residual solvent or water.

5 15. The packaging material of claim 11, wherein the packaging material has a degree of cure of at least 5 MEK rubs.

16. The packaging material of claim 15, wherein the packaging material has a degree of cure of at least 10 MEK rubs.

10 17. The packaging material of claim 16, wherein the packaging material has a degree of cure of at least 20 MEK rubs.